

Date: Wednesday, 1/11/2006 4:21:13 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET		
Job Number	: 25441E			Part Number	: D31991		
Estimate Number	: 10283			Drawing Number	: D3199 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 1/11/2006	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	: Y /	Type	: MACHINED PARTS	Due Date	: 2/18/2006 Qty: 36 Um: Each		
Previous Run	: 24267E						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:C Removed Scribing 05-11-05 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description	
1.0	PG	PURCHASING	<i>already on order P.O 377</i>
	Comment: PURCHASING		
	Issue P/O: _____		
	Email or Ship DXF file to vendor		
	Laser Cut D3199-1 bracket per Dwg D3199		
	Material release note is required		
2.0	D31991F	Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 36.0000 Each(s)		
	Bracket		<i>u</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Receive & Inspect For Transit Damage		
	Ensure material certification is attached		
4.0	QC6	DIMENSIONAL CHECK	
	Comment: DIMENSIONAL CHECK		
5.0	BRAKE NC	NC BRAKE	
	Comment: NC BRAKE		
	1-Deburr if necessary		
	2-Form as per Dwg D3199		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



4.0.1.8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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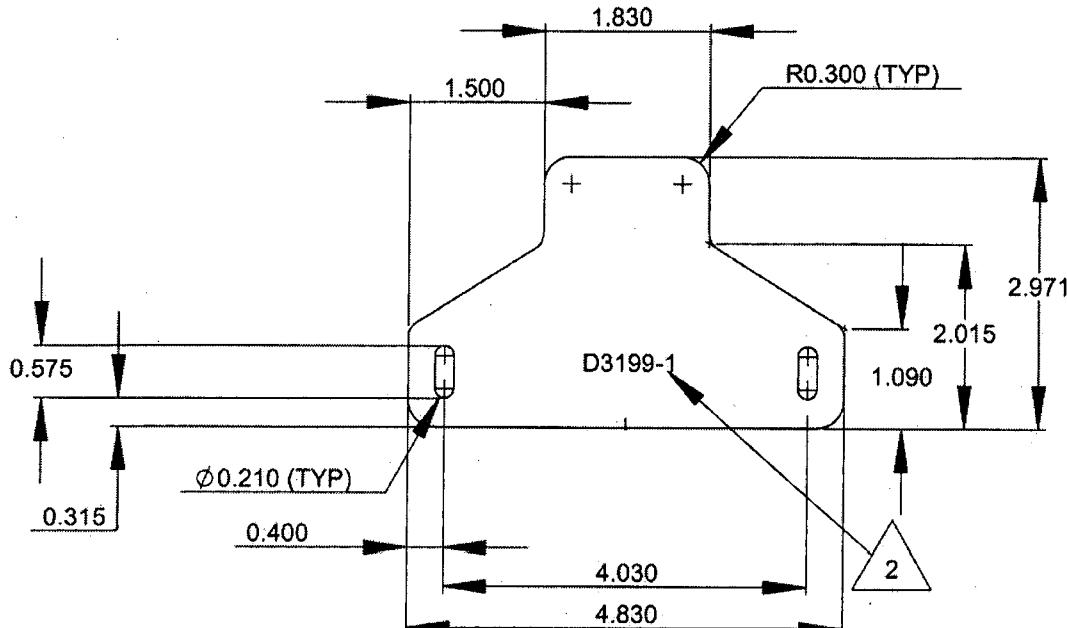
NOTE: Date & initial all entries



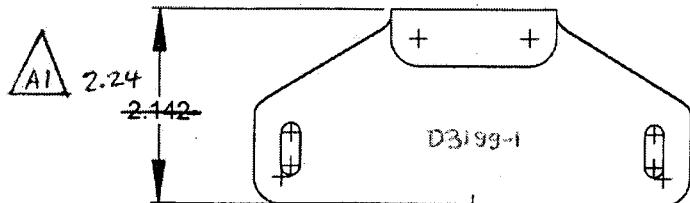
ONE COPY ISSUED
COP

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3199	SHEET 1 OF 1
DATE	03.08.05	TITLE	SCALE
		BRACKET	1:2
A	03.08.05	NEW ISSUE	
A1	04.03.01	2.24 WAS 2.142	

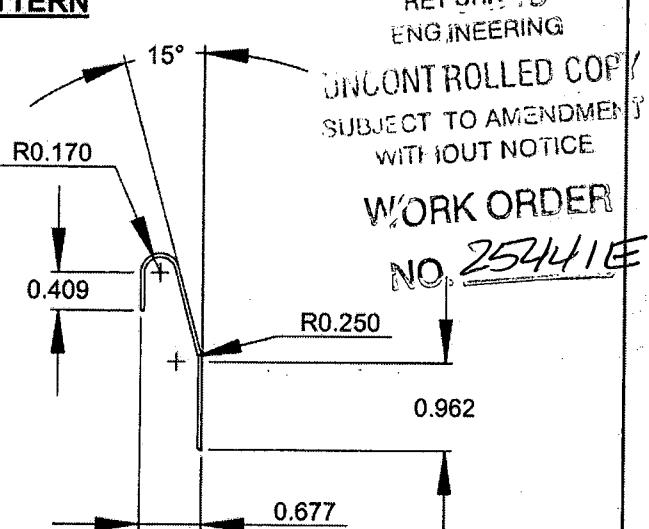
RELEASED
03.09.02 off



D3199-1 FLAT PATTERN



D3199-1 BRACKET



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) SCRIBE DART P/N D3199-1 AS SHOWN.
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES.

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